

ABSTRACT OF THE DISCLOSURE

A paper web (W) is longitudinally divided into slit webs of desired widths and the slit webs are wound into rolls (R) about roll cores (H) at a winding station (17A, 17B). The web is cut by a web-severing device (16) in conjunction with the roll set change of the winding operation. At least two slitter assemblies (15A, 15B) are employed for slitting the web (W) and, when given ones of the slitter assemblies (15A, 15B) are slitting the web (W) into one set of slit webs, the desired ones of the other slitter assemblies (15A, 15B) are preset into desired slitting width positions for slitting the next set of slit webs. The winding apparatus has slitter assemblies (15) for longitudinally dividing a web (W) into slit webs and a winding station (17A; 17B) for winding the slit webs into rolls (R) and a web-severing device for cutting the web.